

Date: Monday, 5/1/2006 4:22:48 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING ANGLE
Job Number : 26908
Estimate Number : 10415
P.O. Number : NIA Part Number : D2417
This Issue : 5/1/2006 S.O. No. : NIA Drawing Number : D2417 REV. B
Prsht Rev. : NC Project Number : N/A
First Issue : NIA Type : MACHINED PARTS Drawing Revision : B
Previous Run : NIA Material : NIA
Written By : See comment below Due Date : 6/30/2006 Qty: 2 Um: Each
Checked & Approved By : 06.05.02
Comment : Est:C 03.04.14 Reformat; Incorporated D2292;
D2375-3-08-106; D2403 - D2417 KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S063 2024-T3 .063 sheet



Comment: Qty.: 0.0411 sf(s)/Unit Total : 0.0821 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.063" thick
(M2024T3S.063) Batch: M19059
Identify for D2417

SAD 06:05:24 (2)

2.0 SHEAR SHEAR



Comment: SHEAR
Cut blank: 3.300" x 1.550" Grain along 1.550"

N/A 06/05/18

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA328 and Dwg D2417
Stack of 7
Identify as D2417

Water Jet

Dwg B
Prog B

SAD 06:05:24 (2)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:05:24 (2)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK


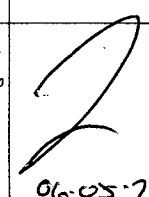
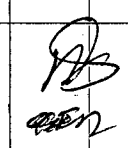
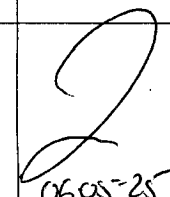

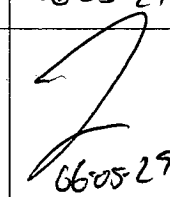
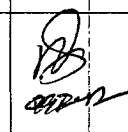
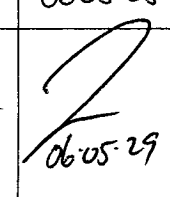
SP 06/05/29 Y2

P10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-25	4	grain in wrong direction. Ensure 2 parts scrap.		Ensure employee checks the grain direction on the Dwg. Scrap: destroy and replace parts.	SAD 06/05/26	 06-05-25		 06-05-25
06-05-29	3	.128 holes ovalized a little by .009, from water jet cutting over the cross ribs.		holes are acceptable and will assemble well.	N/A	 06-05-29		 06-05-29

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING ANGLE

Job Number: 26908

Part Number: D2417

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

En 06/05/29

v2

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D2416

SB 06/06/01

(2)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Open D2417 mounting angle hole to Ø0.437" as per Dwg D2417.

2- Deburr hole

N/A 06/06/01

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 06/06/02

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 06/06/02

(2)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

06/06/05

(2)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5744

06/06/05

(2)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/06

(2)

Job Completion



u 06/06/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	




Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

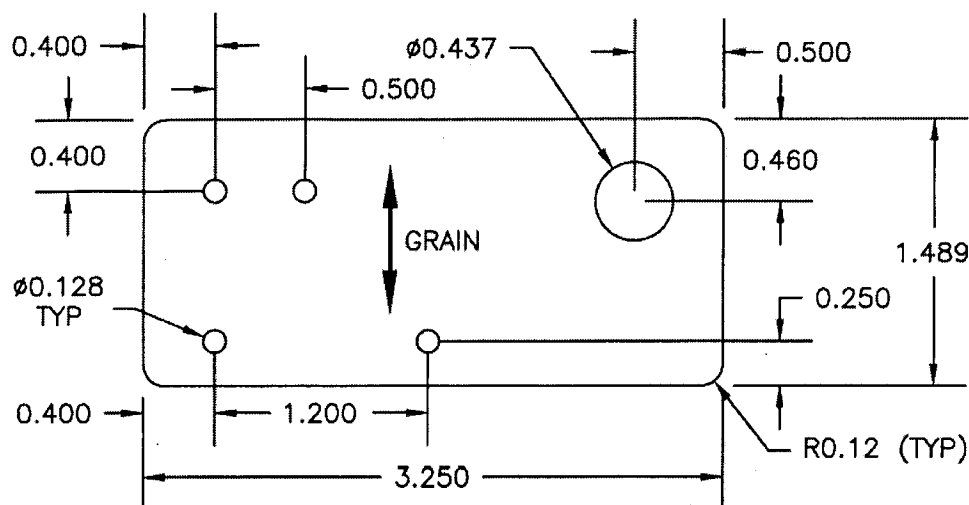
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

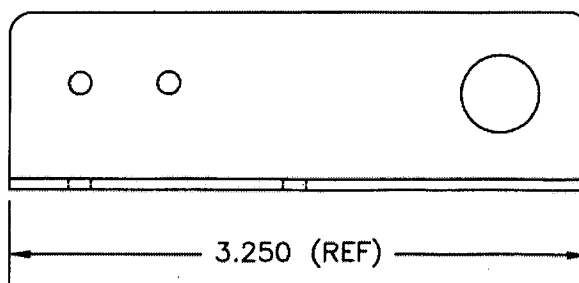
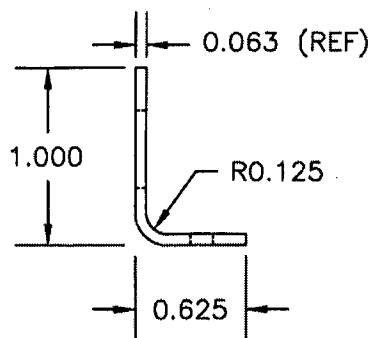


DESIGN BW		DRAWN BY 		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. D2417 REV. B SHEET 1 OF 1	
DATE 03.04.09			TITLE MOUNTING ANGLE SCALE 1:1		
A	95.04.06		NEW ISSUE		
B	03.04.09		ADDED Ø0.128 & FLAT PATTERN		

RELEASED
03.05.07 #



FLAT PATTERN



BEND DETAIL

NOTES:

- 1) MATERIAL: 2024-T3/T3511 0.063" THICK PER QQ-A-250/4 (REF DART SPEC M2024-T3S.063)
2) FINISH: ACID ETCH AND ALODINE AS PER DART QSI 005 4.1
3) DEBURR ALL SHARP EDGES 0.005 TO 0.010
4) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- CONTROLLED COPY
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WITHOUT NOTICE
WORK ORDER
NO 26908

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